

## Garant

### GARANT Master INOX M SlotMachine solid carbide roughing end mill HPC, TiAlN, Ø d11 DC: 8mm



#### Order data

Order number	205450 8
GTIN	4062406276089
Item class	11X

#### Description

##### Version:

With a **new type of knuckle form profile**, optimised for higher feed rates. Improved cutting edge protection thanks to slight edge honing. **Tremendous bending strength** due to the use of **ultra-fine grain substrate**. Number of cutters selected for performance and process reliability.

##### Advantage:

The tool geometry produces particularly tightly rolled swarf that is discharged via flat chip breaker recesses. As a result, the tool maintains an **extremely stable core**.

##### Application:

For roughing machining, particularly suitable for full-slot machining.

##### Recommendation:

To ensure reliable working, particularly for full slot milling, use arbors with **4 cooling channel bores**.

#### Technical description

Flute length $L_c$	19 mm
Helix angle	40 degrees
Corner chamfer width at 45°	0.2 mm
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.035 mm
Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.03 mm
Cutting edge $\varnothing D_c$	8 mm
Shank	DIN 6535 HB to h6

Recess $\varnothing D_1$	7.4 mm
Overall length L	63 mm
Overhang length $L_1$ incl. recess	25 mm
Tolerance nominal $\varnothing$	d11
Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	4
Corner chamfer angle	45 degrees
Shank $\varnothing D_s$	8 mm
Series	Master INOX
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	NR
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	150 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	140 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	120 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	100 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	90 m/min	M

INOX > 900 N/mm <sup>2</sup>	suitable	80 m/min	M
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
Air	suitable		